

Date: Monday, 04/05/2009 3:15:50 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 47728		
Estimate Number	: 11047		
P.O. Number	:	Part Number	: D28441
This Issue	: 04/05/2009 S.O. No. :	Drawing Number	: D2844 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 46844	Material	:
Written By	:	Due Date	: 11/05/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>JUD 09.05.09</u>		
Comment	: Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TRO500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.9941 f(s)/Unit Total: 19.9406 f(s)

304 RD Tube .500 x .035W

M304TRO500W035

Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 21.49" long (Hole ctr. to hole ctr.) using Jig

DT 8012

Batch

M111409

M-k 09/05/05

2.0	BRAKE NC	NC BRAKE
-----	----------	----------



(10X)

Comment: BAND SAW

Form per Dwg D2844 using brake and bending Jig DT 8238-B

Debur

M-k 09/05/05

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S0105102 (10)

4.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

1:20

OVEN TEMPERATURE:

400°

FINISH TIME:

1:50

FL 09/05/07

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/05/2009 3:15:50 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47728

Part Number: D28441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(16)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-05-7

6.0

QC6

DIMENSIONAL CHECK



(10)

Comment: DIMENSIONAL CHECK

ensure parts are still as per dwg D2844

S 09/05/08

(40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 265

SS 09/05/08 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/08

Job Completion



mf
09-05-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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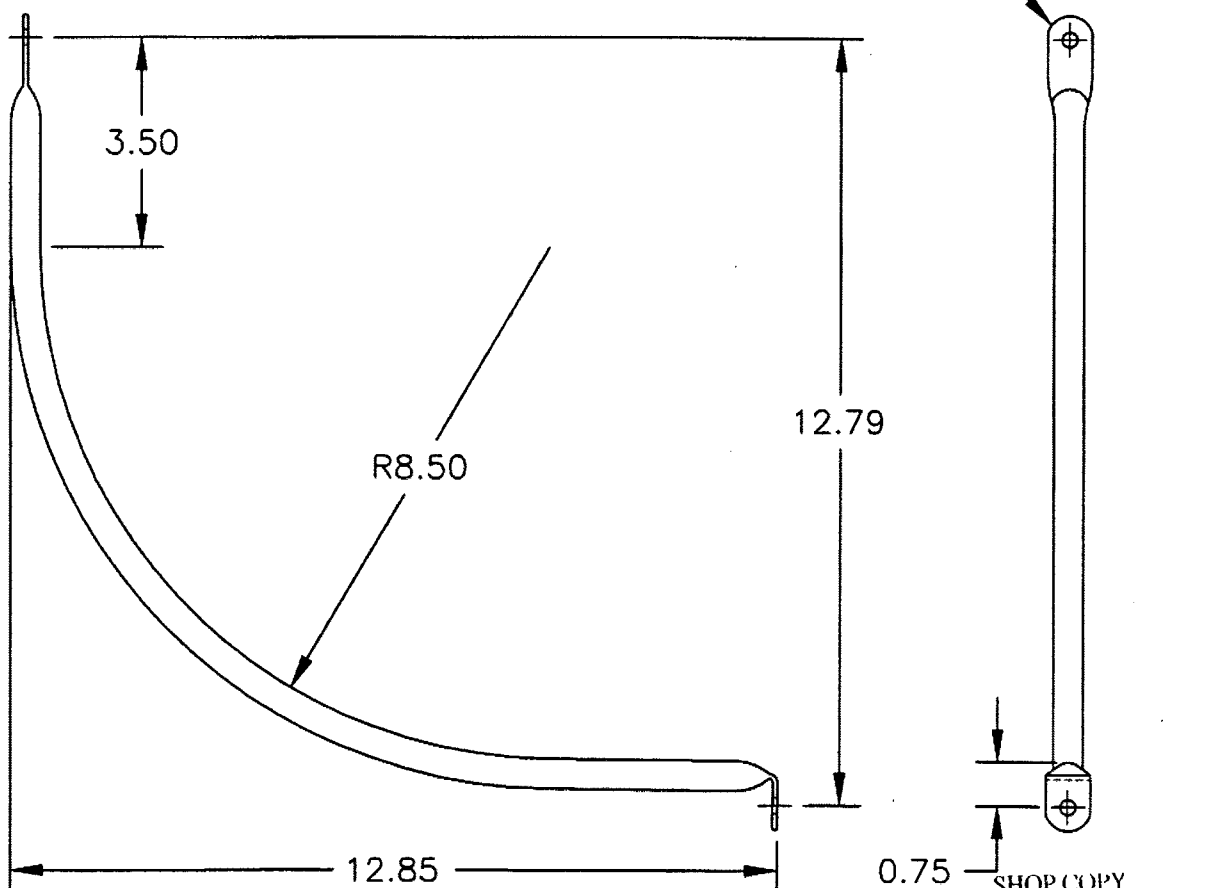
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47728

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

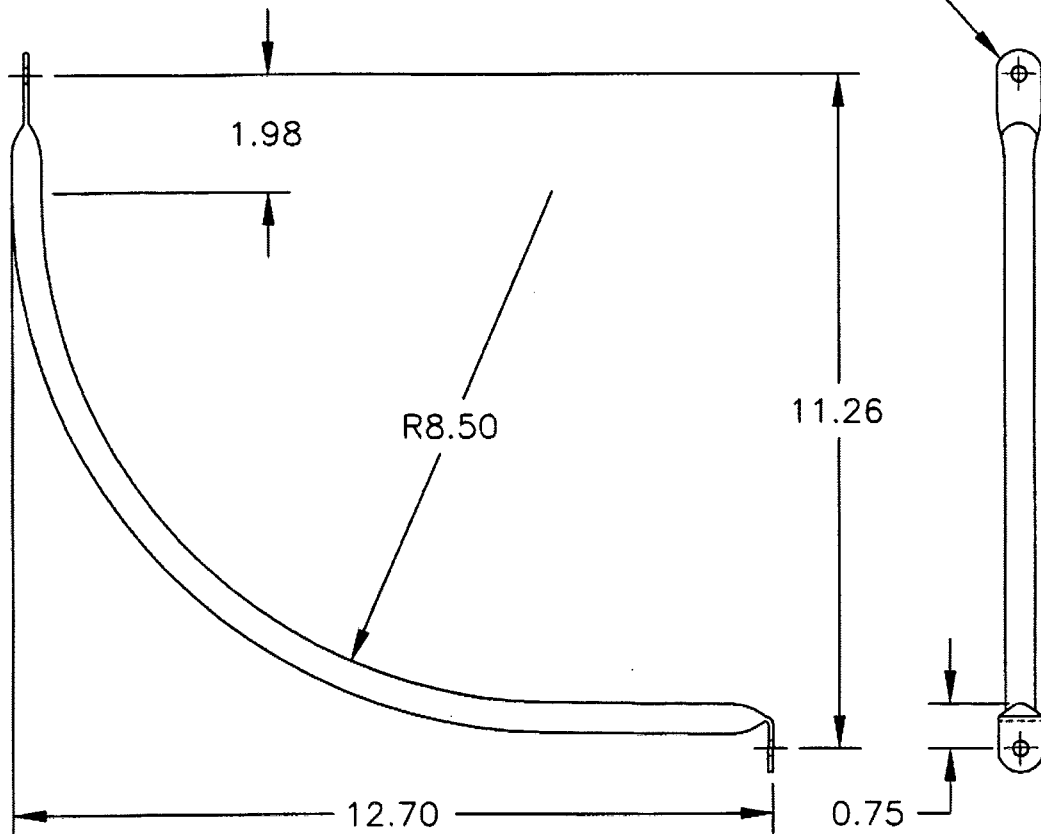
NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>KE</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14	TITLE ARM		SCALE 1:3

RELEASED
98.11.11 *KE*

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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